

Date: Monday, 2/4/2008 11:25:42 AM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|-------------------------------------|-----------------------|------------------|-------------|------|------------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | BRACKET | | |
| Job Number | 37170 | | | | | |
| Estimate Number | 11147 | | | | | |
| P.O. Number | : | | Part Number | D3209041 | | |
| This Issue | 2/4/2008 | S.O. No. : | Drawing Number | D3209 REV A | | |
| Prsht Rev. | NC | | Project Number | N/A | | |
| First Issue | / / | Type : MACHINED PARTS | Drawing Revision | A | | |
| Previous Run | 30832 | | Material | : | | |
| Written By | : | | Due Date | 2/15/2008 | Qty: | 4 Um: Each |
| Checked & Approved By | : | | | | | |
| Comment | Est A 04.06.09 New issue KJ/RF | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--|
| 1.0 | M6061T6B1500X01250 | 6061-T6 Bar 1.5" x 1.25" | |
| | | | |
| | | Comment: Qty.: 0.1838 f(s)/Unit Total : 0.7350 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 Batch: M104183 | |
| 2.0 | BAND SAW | BAND SAW | |
| | | | |
| | | Comment: BAND SAW Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1 Deburr and Tumble | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 5.0 | QC8 | SECOND CHECK | |
| | | | |
| | | Comment: SECOND CHECK | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:25:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37170

Part Number: D3209041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M/T

08/02/06

7.0 POWDER COATING

POWDER COATING



m 106442

(4)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

F/T 08/02/07

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/T

08/02/07

9.0 D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch
1 D3209-3 Bushing 29907

Press fit bushing into the bracket as per Dwg D3209

A8 08/02/07 (4)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/07 (4)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

A8 08/02/07 (4)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H 08/02/08

Job Completion



U 08/02/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 37170 |
| Description: Bracket | Part Number: | D3209-1 |
| Inspection Dwg: D3209 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

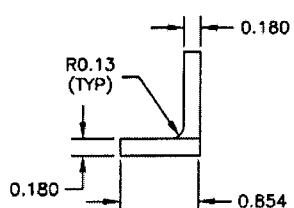
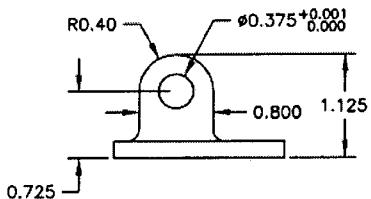
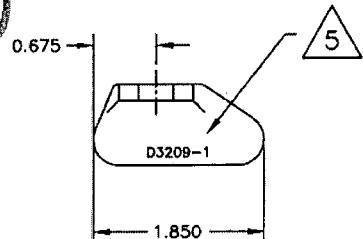
X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L | Audited by: | S.F | Prototype Approval: | N/A |
| Date: | 08/02/05 | Date: | 08/02/05 | Date: | N/A |

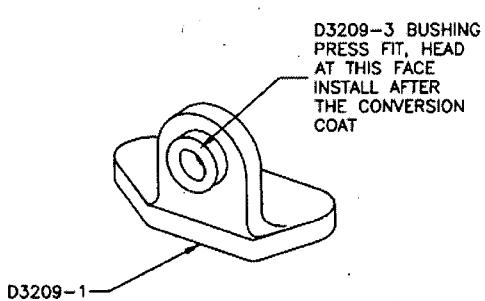
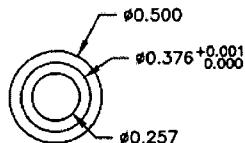
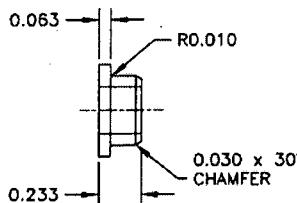
| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 05.02.17 | New Issue (P/O D3209-041) | KJ/JLM | JG |

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3209 | REV. A SHEET 1 OF 1 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.04.05 RF

2

D3209-1 BRACKET

3

D3209-3 BUSHING
SCALE 1:2

4

D3209-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 37170

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX® (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES